

# Work Order ID 108575

\*108575\*

Page 1

Tuesday, October 22, 2013 10:40:17 AM

Item ID: D2281

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Jack Saddle

Stop

\*NS2\*

Start Date: 10/22/2013 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/1/2013 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: UMF

Date: 13-10-22

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G 2-

Deburr if necessary

304.080\*

20

0

Jm 13-10-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

20

0

Jm 13-10-22

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS

27

4-89

13 10 22

20

# Work Order ID 108575

Tuesday, October 22, 2013 10:40:17 AM

**\*108575\***

Page 2

Item ID: D2281

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Jack Saddle

Stop **\*NS2\***

Start Date: 10/22/2013 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/1/2013 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr

N/A

DAS  
30  
9-89

140

**\*140\***

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form as per D2281 using D2281-T2

DAS  
30  
9-89

20

13/10/24

150

**\*150\***

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

DAS  
30  
9-89  
B 10 24

20

# Work Order ID 108575

\*108575\*

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Tuesday, October 22, 2013 10:40:17 AM

Item ID: D2281 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Jack Saddle  
 Start Date: 10/22/2013 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 11/1/2013 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
*160*									
Packaging	Memo	0.00				20		13-10-29	MAL
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

*[Signature]* 13/10/30  
 ME  
 13-10-29

# Picklist Print

Tuesday, October 22, 2013 10:40:15 AM

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Work Order ID: 108575  
Parent Item: D2281  
Parent Item Name: Jack Saddle

Start Date: 10/22/2013      Required Date: 11/1/2013  
Start Qty: 20.00      Required Qty: 20.00

Comments: IPP Rev:A      Removed from 9 Digit      05-12-02      JLM  
IPP: rev B      06.07.17      waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA		Purchased	No			100	sf	141.4500	0.125	3			
304SS sheet .080													

Jm13-10-22

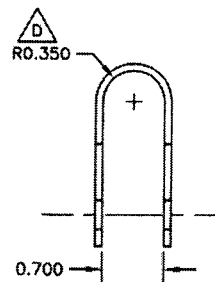
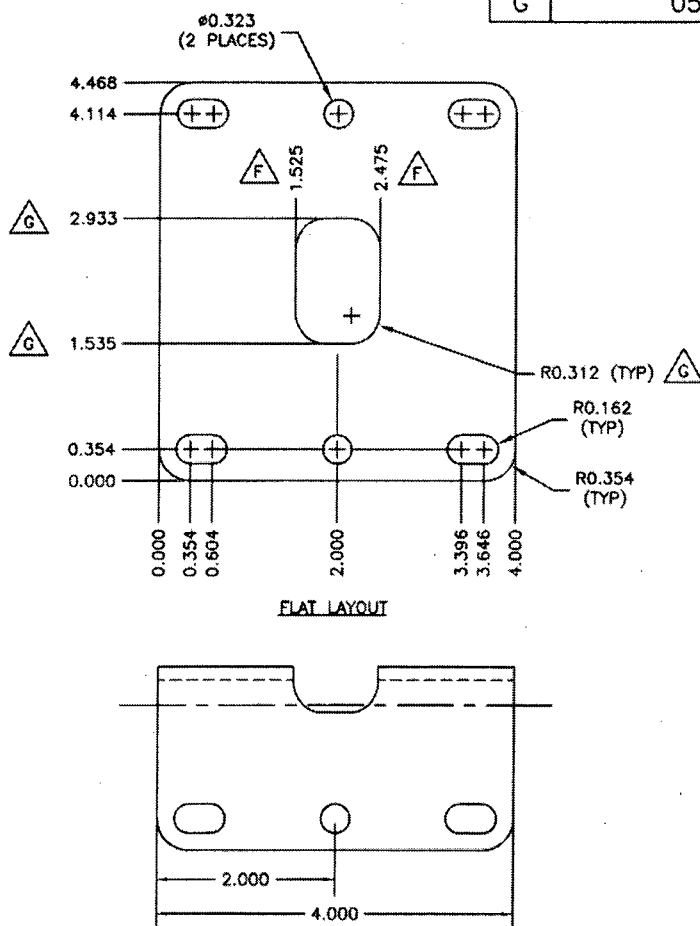
Location	Loc Qty	Loc Code
MAT020	141.45	
117933	4.5	
119276	9.7	
M126075	127.25	

126075



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED  
*[Signature]*  
05/08/11



#### D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	108575
<b>Description:</b> Jack Saddle		<b>Part Number:</b>	-D2281
<b>Inspection Dwg:</b> D2281 <b>Rev:</b> G		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.474"	✓		✓	J/moi
4.114	+/-0.010	4.117"	-		✓	
2.933	+/-0.010	2.936"	-		✓	
1.535	+/-0.010	1.539"	-		✓	
0.354	+/-0.010	0.359"	-		✓	
0.354	+/-0.010	0.360"	-		✓	
0.604	+/-0.010	0.607"	-		✓	
2.000	+/-0.010	1.999"	-		✓	
3.396	+/-0.010	3.399"	-		✓	
3.646	+/-0.010	3.642"	-		✓	
4.000	+/-0.010	4.004"	-		✓	
1.525	+/-0.010	1.527"	-		✓	
2.475	+/-0.010	2.477"	-		✓	
Ø0.323	+0.006/-0.001	0.323"	-		✓	
0.080	+/-0.010	0.074"	-		✓	

<b>Measured by:</b> Jn	<b>Audited by:</b> DAS 27 9-89	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 13-10-20	<b>Date:</b> 13.10.20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>